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D3916-041 Job Sheet 193622



Part No: D3916-041

Job Qty: 4 pcs

Part Name: Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/17/19

Job Tracking No:

Due Date: 5/7/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV A IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	4 pcs	5/7/19		0.00	1.96	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
105	QC 5	4 pcs	5/7/19		0.00	0.00	Large Fab - 9		Is
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
107	Large Fab - Basket - 2 - B4B	4 pcs	5/7/19		0.00	2.67	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		

Plex 4/17/19 10:28 AM Dart.Macdonald.Dara

						Large Fab - 3 - B4B	
						Large Fab - 4 - B4B	
						Large Fab - 5 - B4B	
						Large Fab - 6 - B4B	
						Large Fab - 7 - B4B	
						Large Fab - 8 - B4B	MAC
						Large Fab - 9 - B4B	
						QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
110 QC 5	4 pcs	5/7/19	0.00	0.00		QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	DAS
						QC 5 - 24	24 MAY 03 2019
						QC 5 - 3	9-89
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
120 QC 10	4 pcs	5/7/19	0.00	0.00		QC 10 - 10	
						QC 10 - 18	
						QC 10 - 24	DAS
						QC 10 - 43	24 MAY 03 2019
						QC 10 - 50	9-89
						QC 10 - 58	
						QC 10 - 9	
130 Packaging 3-1 - Stock - B4B	4 pcs	5/7/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	DAS
						Packaging 3 - 18 - B4B	24 MAY 03 2019
						Packaging 3 - 19 - B4B	9-89
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	

					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	4 pcs	5/7/19	0.00 0.00	QC 21 - SA - 21	21
					QC 21 - SA - 70	21
					QC 21 - SA - 53	MAY 03 2019

Part Op 100 - 1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9567 *** Make line at 9.00" and use jig for other Descriptions: lines, and ensure seam in place on side of tube when bending*** 3- Trim access tube material to finish size as per dwg D3916 4- Drill and chamfer holes as per dwg D3916-1 using DT9605
 105 - (QC5- Inspect part completeness to step on W/O)
 107 - (Weld per dwg A/R S.S. rod Batch:) 1- weld bushing as per dwg D3916 2- grind welds flush
 110 - (QC5- Inspect part completeness to step on W/O)
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (Identify as per dwg & Stock Location:) LOCATION: WA004-5
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3759-1	Bushing	28 pcs (7 ea)	100-Large Fab - Basket - 1	33x 5170184
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	16.6640 ft (4.166 ea)	100-Large Fab - Basket - 1	5160813 5x 5176865

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D3759-1	28	25	0
	M304TS0.750W.049	17	180	0

Part Specifications

Specifications could not be found.

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Container No: S177113



Part: D3916-141

Job No: 193622

Serial No/Batch: 9177113

Revision:

Inspector:

Exp Date:

Instructions: Various SFCs

Date: 05/02/19